

# Work Order ID 81519

*Report*  
**\*81519\***

Page 1

May-30-12 7:53:54 AM

Item ID: D350-748-101

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: U/R

Stop **\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 3/15/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/04/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-748-141	F U/R

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPPD350-748-101

CHG002

*W 12.06.25*

110

**\*110\***

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - CROSSTUBES

Memo

0.00

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT \_\_\_\_\_

*12-5-10*

120

**\*120\***

QC

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

*12-5-11*

*PTO*

*Tesne P/O to Met cor*

*P/O: 16954*

*CD 12/06/04*

*L attached code to w/o*

*12-5-11*

*P/O*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 350-740-101 PAR #: \_\_\_\_\_ Fault Category: X-tube NCR: Yes ☒ No ☐ DQA: AW Date: 12/07/04  
 Resolution: \_\_\_\_\_ Disposition: Reserve QA: N/C Closed: CK Date: 12/7/5

NCR: <u>12-1552</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-5-15	125	Tube 13 <del>is</del> high After Stress release	<u>CP</u> 12-5-15 12.05.30	Trim to 23.4 High. Acceptable after trimming	<u>MB</u> 12-5-15	<u>S</u> 12/05/15	<u>CP</u> 12-5-15 12.05.30	<u>S</u> 12/07/31
		R.C Process						

NOTE: Date & initial all entries

# Work Order ID 81519

**\*81519\***

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May-30-12 7:53:54 AM

Item ID: D350-748-101 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: U/R Stop **\*NS2\***  
 Item Name: Crosstube Installation, High Fwd  
 Start Date: 3/15/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 4/04/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 <b>*125*</b> HandFXtube Hand Finishing Crosstubes	<b>Memo</b> ***Stress relief*** Heat treat crosstube as per QSI010 4.3 Temp: _____ Start time: _____ Finish time: _____	0.00 0.00							
127 <b>*127*</b> QC Quality Control	QC6- Inspect dimensions to drawing  <b>Memo</b>	0.00 0.00							

*Handwritten signature/initials*

*Handwritten date: 12-5-16*



# Work Order ID 81519

**\*81519\***

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March-15-12 8:43:17 AM

Item ID: D350-748-101

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: U/R

Stop **\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

**\*130\***

Crosstubes

Crosstubes

Crosstubes

Memo

0.00

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,  
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-141

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: u/125

*Rm/JW 12-5-17*

*> mo 12-5-17*

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)

*Sic/10/30*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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March-15-12 8:43:17 AM

Item ID: D350-748-101

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: U/R

Item Name: Crosstube Installation, High Fwd

Stop **\*NS2\***

Start Date: 15/03/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Outsource process-Cadplate per QSI017 4.1.9.1 0.00

**\*150\***

Outsource3

Outsource process - Cad plate

Memo

Issue P/O: 17084  
Stress relief at 375° for 5 hours  
Magnetic Particle Inspect per ASTM E1444  
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2  
Embrittle relief at 375° for 8 hours, Chromate Treat  
Possible Supplier: Southwest United Industries  
Ensure Certificate of Conformity is attached

0.00

*CA 12/06/04 ①*

160 Receive & Inspect for Damage & Mat'l Certs 0.00

**\*160\***

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

0.00

*ix SP 12-5-15*

170 QC5- Inspect part completeness to step on W/O 0.00

**\*170\***

QC

Quality Control

Memo

0.00

*☆ SEE W/D CAG, OVER*

POSITIVE RECALL

EFFECTIVE 12/3/13 AUTH UP  
RELEASED UP DATE 12/6/26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12.03.15	171	LOAD TEST TO 3500 <sup>lb</sup> FOR 1 MINUTE		CP 12/6/18	1	CP 12.03.15 B1000		
12.03.15	172	NDT PRO: 17258 and P-12/4/18 (1) CZ 12/06/19 (1)				CP 12.03.15 B1000		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



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Item ID: D350-748-101

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: U/R

Stop **\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
<b>*180*</b>	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 - B121746								start: 12:30 Finish: 1:15
	2-Prime Outside of Tube as per Dart QSI 005 4.2 - B121625								start: 5:15 Finish: 5:45
190	QC14- Inspect Spray Paint	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200		0.00							
<b>*200*</b>	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer								
	2-Install Abraison strips as per Dwg D350-748-141 & QSI 035.								
	3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS								

12 - 6 - 21

12 06 24

12 06 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Revision ID: U/R

Stop **\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									
220	Pick Kit	0.00							
<b>*220*</b>									
Packaging	Memo	0.00							
Packaging									
230	QC4- 100% Inspect kits for completeness	0.00							
<b>*230*</b>									
QC	Memo	0.00							
Quality Control									

0 8 120625

12/10/22

1 12/12/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D350-748-101

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Setup Start

**\*NS1\***

Revision ID: U/R

Stop

**\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

0.00

**\*240\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-748-101

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

12/06/25

250

QC21- Final Inspection - Work Order Release

0.00

**\*250\***

QC

Memo

0.00

Quality Control

MLJ 12/06/26  
MEF  
12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Work Order ID: 81519

**\*81519\***

Parent Item: D350-748-101

**\*D350-748-101\***

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:A New Issue 06-07-05 JLM  
 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ  
 IPP Rev:C Rev B 07-11-15 DD  
 IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD  
 IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F  
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-141TRN		Manufactured	No			110	Each	0.0000	1	1			
<b>*D350-748-141TRN*</b>													

Crosstube Turning Detail

ALS4-1032-225

Purchased

No

200

Each

1,102.000

1

1

**\*AI S4-1032-225\***

Insert

## Location

## Loc Qty

## Loc Code

118520

ST281

1019

108696

146

110768

62

118386

55

118966

68

120671

688

ST282

83

120410

70

120451

13

AN960JD10

NAS1149D0363J

Purchased

No

200

Each

0.0000

1

1

**\*AN960.ID10\***

Washer

121524

12/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 81519

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Parent Item: D350-748-101

\*D350-748-101\*

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured No

200 f

199.5445 1.181 1.243158

\*D2856-400\*

Abrasion Strip

\*\*

*W/120624*

## Location

## Loc Qty

## Loc Code

*81875*

ST409

199.5445

63735

0.6696

68076

0.3149

71164

8.46

79551

190.1

D3502-1

Manufactured No

200 Each

39.0000 2 2

\*D3502-1\*

Support

\*\*

*W/120624*

## Location

## Loc Qty

## Loc Code

*77041*

ST051

39

73419

19

74873

20

MS21920-20

Purchased No

200 Each

60.0000 2 2

\*MS21920-20\*

Clamp (per MIL-DTL-8783C)

\*\*

*W/120624*

## Location

## Loc Qty

## Loc Code

*121274*

LG050

60

116799

8

120475

2

120676

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Parent Item: D350-748-101

**\*D350-748-101\***

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

200

Each

258.0000

1

1

**\*MS27039-1-10\***

Screw

\*\*

*M/12 06 24*

## Location

## Loc Qty

## Loc Code

*122027*

GA

100

120449

100

ST291

158

120120

158

AN4-41A

Purchased

No

220

Each

387.0000

8

8

**\*AN4-41A\***

Bolt

\*\*

*8*

## Location

## Loc Qty

## Loc Code

ST360

387

115108

3

115705

7

117619

27

118451

50

118838

50

119328

100

120423

150

AN4-6A

Purchased

No

220

Each

1,649.000

16

16

**\*AN4-6A\***

Bolt

\*\*

*1216228*

## Location

## Loc Qty

## Loc Code

ST356

1649

119017

1649

*16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-748-101

**\*D350-748-101\***

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-32A Purchased No 220 Each 256.0000 4 4

**\*AN5-32A\***

Bolt

\*\*

*f*

Location	Loc Qty	Loc Code
ST339	256	
119328	100	
119862	50	
120423	75	
120717	1	
120910	30	

AN960JD416 NAS1149D0463J Purchased No 220 Each 14.0000 32 32

**\*AN960.ID416\***

Washer

\*\*

*M121912*

Location	Loc Qty	Loc Code
ST351	14	
116289	14	

AN960JD516 NAS1149D0563J Purchased No 220 Each 0.0000 8 8

**\*AN960.ID516\***

Washer

\*\*

*M119646*

D3500-1 Manufactured No 220 Each 35.0000 4 4

**\*D3500-1\***

Saddle

\*\*

*B73405*  
*B73595*  
*12/6/12*

Location	Loc Qty	Loc Code
ST424	35	
73406	8	
76000	27	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3501-1 Manufactured No

220 Each 361.0000 16

**\*D3501-1\***

Bushing

\*\*

16  
S

## Location

## Loc Qty

## Loc Code

ST051

361

67757

4

70682

83

73391

6

74866

207

77033

61

16

MS21042L4

Purchased No

220 Each 5,585.000 24

**\*MS21042L 4\***

Nut

\*\*

24  
M121444 S

## Location

## Loc Qty

## Loc Code

ST300

5585

117441

51

117601

157

117885

16

118451

133

119017

✓ 232

119075

2996

121011

2000

MS21042L5

Purchased No

220 Each 1,602.000 4

**\*MS21042L 5\***

Nut

\*\*

4  
shokup

## Location

## Loc Qty

## Loc Code

ST300

1602

116105

5

116548

43

117611

42

118179

12

119109

1500

4

March-15-12 8:43:21 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

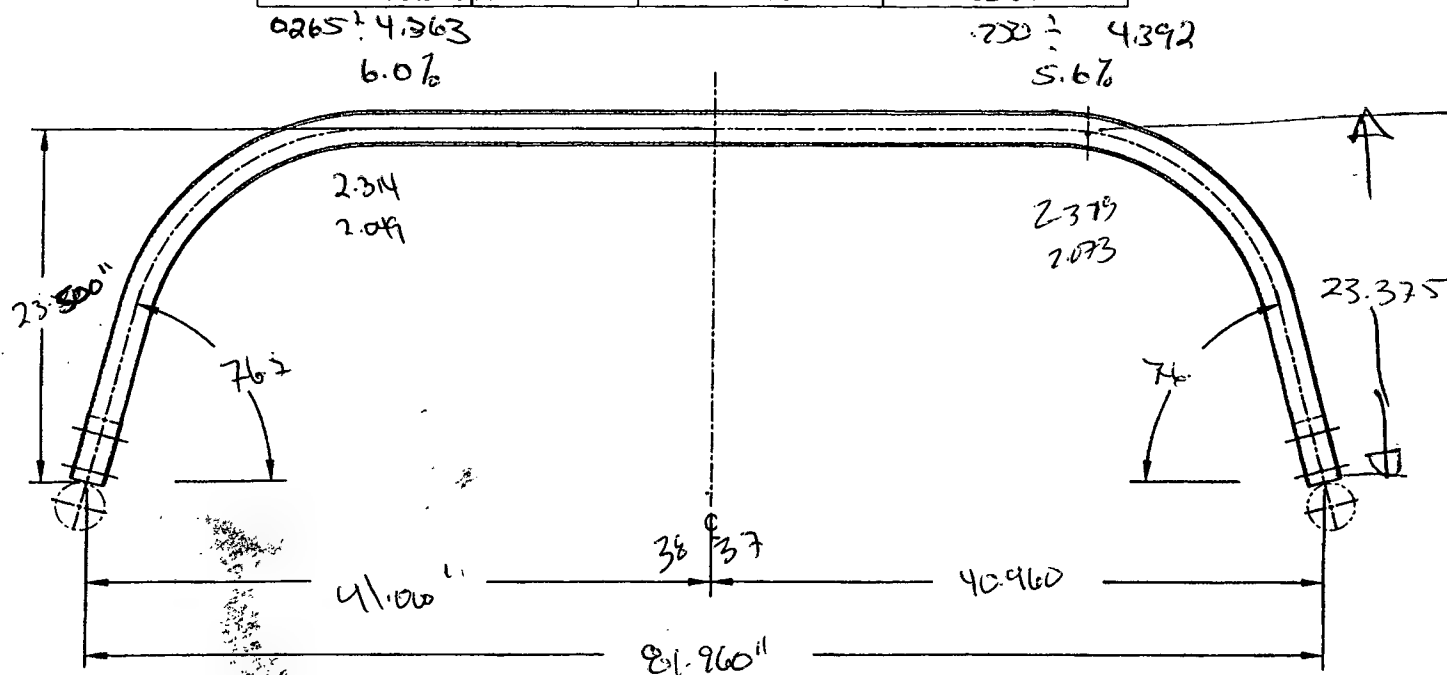
**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81519
<b>Description:</b> Crosstube High Fwd (AS350/355)		<b>Part Number:</b>	D350-748-101
<b>Inspection Dwg:</b> D350-748-141		<b>Rev:</b> F	<b>Page 1 of 1</b>

Bend.

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
SIDE A = 6.0% crush @ 36 passes
SIDE B = 5.6% crush @ 37 passes
Twist = 0.091
OK (1/12/05) Q51 042

QC15 Inspection	5
Date	12/05/06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE.(NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty	Part Number	Description
	-141		
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115  
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.  
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO  
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,  
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,  
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.  
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE  
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO  
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT  
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN  
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 81519 MLJ  
12/03/15

UNDER REVIEW

11/07/12

RELEASED  
2011-01-18

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	99	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	99		
CHECKED	h		
MFG. APPR.	E		
APPROVED	HA		
DE APPR.	HA		
DATE	10.11.23	DRAWING NO.	REV. F
		D350-748-141	SHEET 1 OF 4
		TITLE	SCALE
		CROSSTUBE (AS 350/355 HI FWD)	NTS
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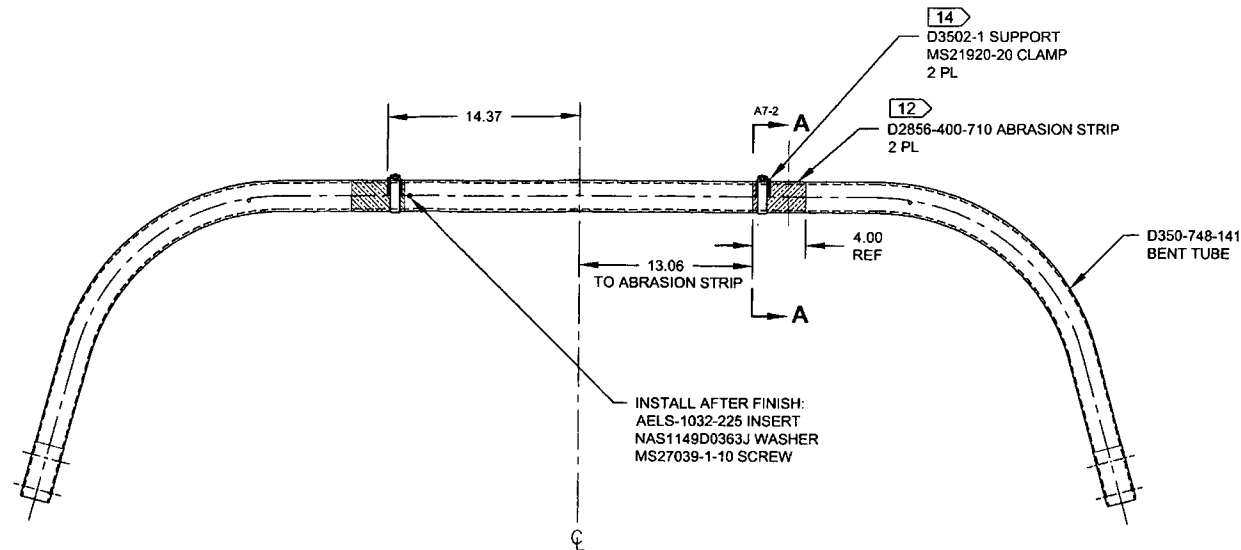
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

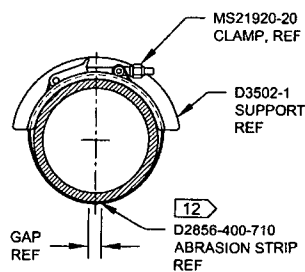
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D350-748-141  
ASSEMBLY DETAIL**



**SECTION A-A** D4-2  
SCALE 4X

UNDER REVIEW

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2011-01-18

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	12	DRAWING NO.	REV. F
MFG. APPR.	12	D350-748-141	SHEET 2 OF 4
APPROVED	12	TITLE	SCALE
DE APPR.	12	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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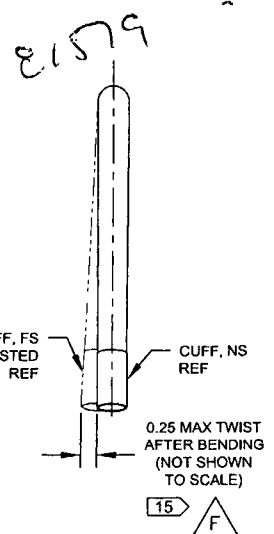
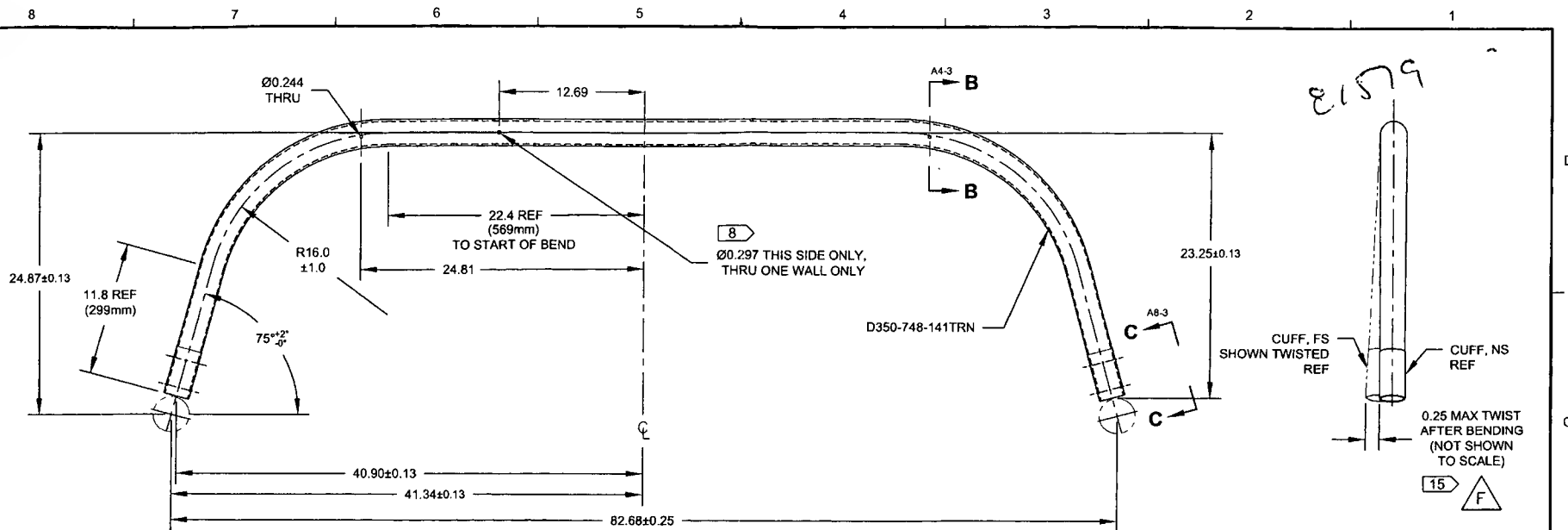
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

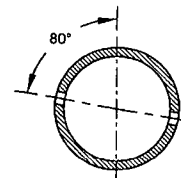
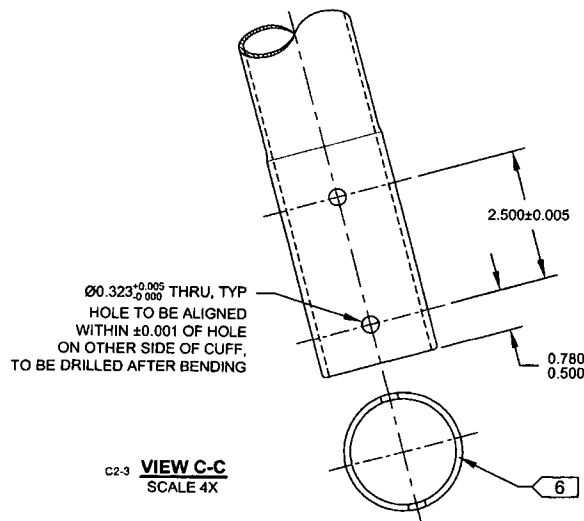
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D350-748-141**  
**BENDING AND DRILLING DETAIL** 10



**SECTION B-B** D3-3  
 SCALE 4X

UNDER REVIEW  
 11.07.12

RELEASED  
 2011-01-18  
 MP

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. F
MFG. APPR.	3	D350-748-141	SHEET 3 OF 4
APPROVED	3	TITLE	SCALE
DE APPR.	3	CROSSTUBE (AS 350/355 HI FWD)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

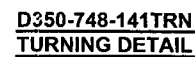
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





11.07.12



RELEASED  
2011-01-13

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D350-748-141</b>  <b>REV. F</b> SHEET 4 OF 4  TITLE <b>CROSSTUBE (AS 350/355 HI FWD)</b> SCALE <b>NTS</b>  COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COGNITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>
DRAWN	90	
CHECKED	15	
MFG. APPR.	15	
APPROVED	15	
DE APPR.	15	
DATE	10.11.23	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Metcor Inc.  
560, boul. Arthur-Sauvé  
St-Eustache (Québec) J7R 5A8  
Tél : 450-473-1884

**Certificat de Conformité**  
**Certificate of Compliance**

BON DE TRAVAIL order	CHARGEMENT load
175926	1

CLIENT / customer 215  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
16954		Steel		

**SPÉCIFICATIONS DU PROCÉDÉ**  
processing specifications

STRESS REL

SAE AMS 2759/1 REV.E

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results  
Visual

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
7	210	D350-748-101 (1) CROSS TUBE  (1) D350-748-101 CROSS TUBE  (1) D350-748-101 CROSS TUBE  (1) D350-748-101 CROSS TUBE  (1) D350-748-101 CROSS TUBE  (1) D350-748-101 CROSS TUBE  (1) D350-748-101 CROSS TUBE  CONTENANT: 1 PALETTE

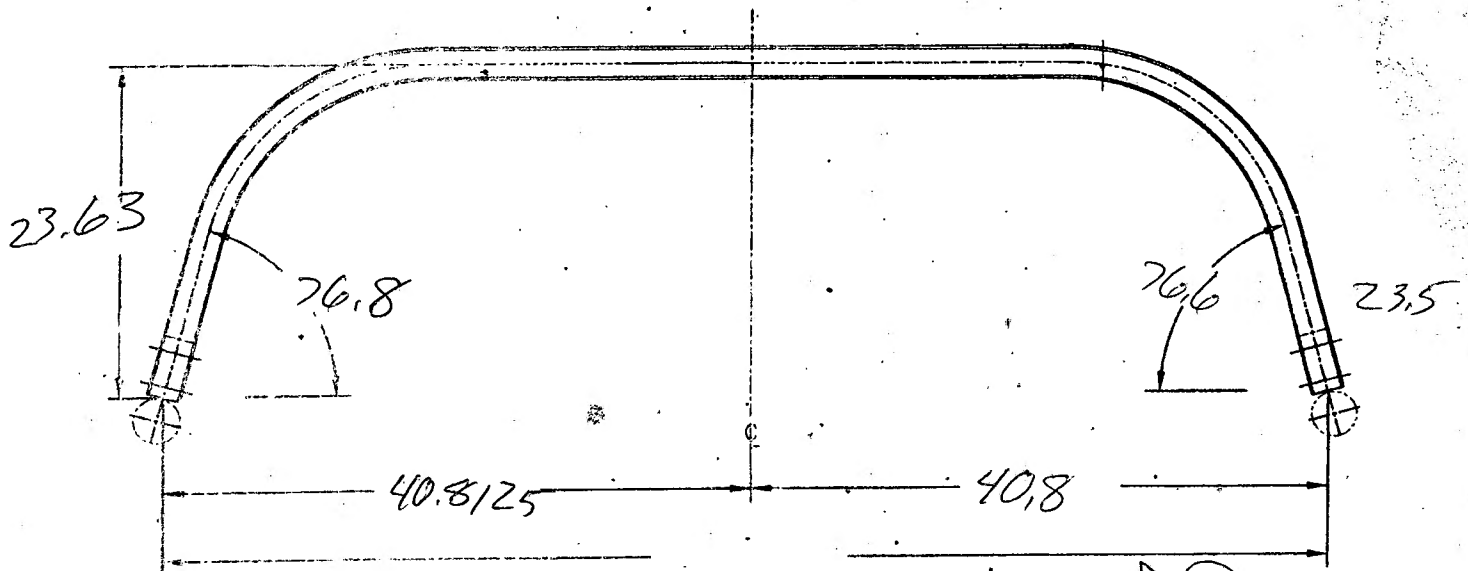
COMMENTAIRES / comments



DART AEROSPACE LTD		Work Order:	81519
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: F		Page 1 of 1	

*Stressed*

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



*DP 12-5-14*

Comments	
<i>TWIST 0.110</i>	<i>Acceptable 12.05.15</i>
<i>TRIM TO 23.40</i>	<i>OK</i>

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	

115110  
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**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Jun-12-2012

**CONSIGNEE TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 114972  
**INVOICE #:** 60875

**CONTRACT OR  
PURCHASE ORDER #** PO17084

**DESCRIPTION:** CROSSTUBE

**QTY** 1

**P/N #** d350-748-101

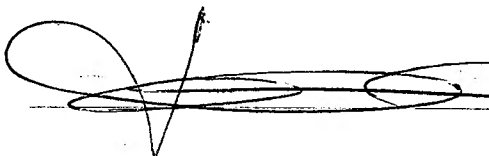

**S/N #** 81519

STRESS RELIEVE HEAT CHART # 12-546. MPI-IAW ASTM-E-1444.  
CADMIUM PLATE IAW AMS-QQP-416C TYPE 2 YELLOW CLASS.  
BAKE HEAT CHART # 12-573. MPI IAW ASTM-E1444.

*8/12/04/18*

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**

# LIQUID PENETRANT TEST REPORT



PAGE 1 OF 1

DATE June 19/2012  
 ACUREN JOB NO. 198-12-0265  
 PO/WO No. 17084  
 WORK LOCATION SAVE  
 ACCEPTANCE STD ASTM 1417/EN 1038 REV./DATE 2005

DATE  
 ACUREN JOB NO.  
 PO/WO No.  
 WORK LOCATION  
 ACCEPTANCE STD

F.P.I. on CROSS TUBES  
 SEE RESULTS

① Pcs

OBJECT  
 (M.S.D.) - FINED

JOB DESCRIPTION  
 PROCEDURE No. LT002 REV./DATE 2008 TECHNIQUE No. LT002 REV./DATE 2008  
 MATERIAL 4130 STEEL THICKNESS VARIOUS

PART NO. SEE RESULTS  
 SCOPE A WET FLUORESCENT LIQUID PENETRANT EXAMINATION WAS COMPLETED 100% ON EXTERNAL SURFACE

TEST DETAILS  
 METHOD ☒ FLUORESCENT ☐ VISIBLE  
 FAMILY BRAND MAGNAFLUX  
 PENETRANT 2LG7 MINIMUM DWELL TIME 45 MIN.  
 PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN.  
 DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN.  
 DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY  
☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
 BLACK LIGHT S/N 16459 ☒ OUTPUT > 1000  $\mu$  W/cm<sup>2</sup> ☐ AMBIENT < 2 fc  
 LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
 OTHER LAB NO  
 LIGHT METER S/N 1098866 CAL DUE DATE July 20-2012

TEST SURFACE  
 SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
 SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F  
☒ METRIC ☐ IMPERIAL

RESULTS-			
W.O.s - CROSS TUBES.			
1	-	83701	✓
1	-	83699	✓
1	-	83698	✓
1	-	81517	✓
1	-	81518	✓
1	-	84380	✓

12 06 19

Scope of Services  
 Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expected that descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be taken as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use of the services referred to herein exceed the amount paid for such services. No other warranty is made or intended by Acuren Group Inc.

SIGNATURES  
 CLIENT REPRESENTATIVE Matthew Murdoch PRINT  
 TECHNICIAN (SIGNATURE): Mike Lattin  
 NAME (PRINT): Mike Lattin  
 CGSB LEVEL 1 SNT LEVEL 6066  
 CGSB REG. No. 6066  
 REPORT REVIEWED BY: Matthew Murdoch DTR # E 6350  
 NAME INIT  
 2<sup>ND</sup> TECHNICIAN  
 CGSB LEVEL SNT LEVEL  
 CGSB REG. No.